Date:

Tuesday, 8/21/2007 9:09:06 AM

User:

Chantal Lavoie

Process Sheet

Drawing Name

Part Number

Material

Due Date

Drawing Number

Project Number

Drawing Revision

: LUG

: D22491

: N/A

:N/A

: 8/24/2007

: D2249 REV. E

Customer : CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number** : 10839

: NIA P.O. Number This Issue

: 8/21/2007

S.O. No. : µ\∕A

: NC Prsht Rev. First Issue

: NA : 31609A

: SMALL /MED FAB

Checked & Approved By Comment

Est Rev:E

Added Step 9 KJ/RF Now on Wateriet 07-03-08 JLM

Additional Product

Previous Run

Written By

Job Number:



Seq. #:

Machine Or Operation:

Description:

M304S16GA 1.0

304/316 .063 Sheet



Comment: Qty.: 0.0903 sf(s)/Unit Total: 3.6120 sf(s)

304/316 .063 Sheet

Batch: 1410513C

SA10 07/08/21

2.0





Comment: FLOW WATER JET

1-Cut as per Dwg D2249

Dwg Rev: Prog Rev:___

2-Deburr if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

SECOND CHECK

Comment: SECOND CHECK

5.0

PACKAGING RESOURCE #1



PACKAGING 1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location: WS



07/08/23



Each

| Dart | Aeı | rosp | ace | Ltd |
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|-------------|-----|------|-----|-----|

| | WORK ORDER CHANGES | | | | | | | | |
|-----------------------|--------------------|-----------------------|--------------------------|-------------------------------|-------------------------------------|---|--|--|--|
| STEP PROCEDURE CHANGE | | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | | | |
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| | STEP | STEP PROCEDURE CHANGE | STEP PROCEDURE CHANGE By | STEP PROCEDURE CHANGE By Date | STEP PROCEDURE CHANGE By Date Qty | STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr | | | |

| Part No: _ | PAR #: | Fault Category: | NCR: Yes No DQA: | Date: <u>0刊8 3</u> 4 |
|------------|--------|-----------------|------------------|----------------------|
| | | | QA: N/C Closed: | Date: |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) Corrective Action Section B | | | | | | | |
|------|------|---|----------------------|------------------------------|----------------|---------------------------|-----------------------|-------------------------|--|
| DATE | STEP | Description of NC Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Verification Section C | Approval Chief Eng | Approval QC Inspecto | |
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NOTE: Date & initial all entries

Date:

Tuesday, 8/21/2007 9:09:06 AM

User:

Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 34115

Part Number: D22491

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE



Job Completion



N 82.58.24

Dart Aerospace Ltd

| W/O: | | WORK ORDER O | WORK ORDER CHANGES | | | | | | |
|---------|------|------------------------|--------------------|-------|-----|-------------------------------------|--------------------------|--|--|
| DATE | STEP | PROCEDURE CHANGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | | |
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| Part No | : | PAR #: Fault Category: | NCR: Yes | No DQ | A: | Date: | | | |

QA: N/C Closed: ____ Date: __

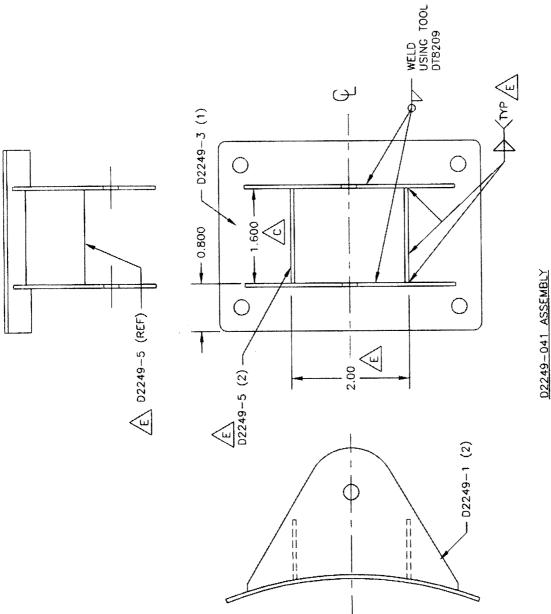
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | | |
|------|------|----------------------------------|----------------------|------------------------------|----------------|--------------|-----------------------|--------------------------|--|--|
| | | Description of NC | | Corrective Action Section B | | Verification | Annestal | A | | |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Section C | Approval Chief Eng | Approval QC Inspector | | |
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NOTE: Date & initial all entries



| DESIG | KE | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
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| CHECK | | APPROVED | DRAWING NO. | REV. | E. |
| | KE | \ | D2249 SHEET | 1 OF | 4 |
| DATE | *************************************** | | TITLE | SCA | LE |
| 99.0 | 9.20 | | FITTING | N | TS |
| Α | | 94.06.20 | NEW ISSUE | ٠. | |
| В | | 95.11.30 | DIMENSION CHANGE | | |
| С | | 95.12.14 | DIMENSION CHANGE | | |
| D | | 98.04.30 | Ø0.261 WAS Ø0.257 (TSR A179) REMOVED DUPLICATE DIMENSIONS | | |
| Ε | | 99.09.20 | ADDED GUSSET | | |

PELEASED 194.10.12 KE



MATERIAL: AISI 304/316 SS, 0.063 THICK
WELD PER DART QSI 004
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED

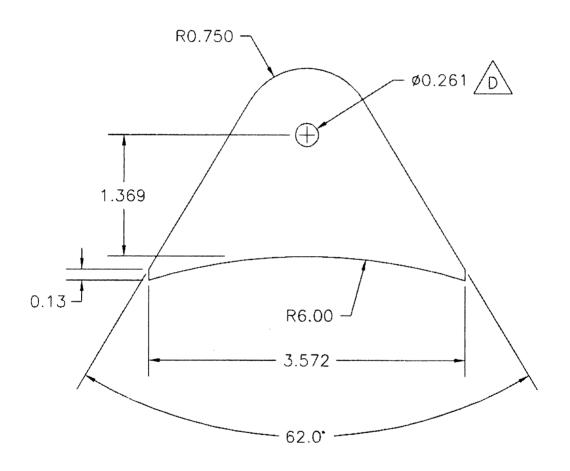
Copyright 1994 by DART AEROSPACE LTD





| DESIGN | DRAWN BY | | ROSPACE LTD ry, dntario, canada |
|-----------|-------------|-------------|------------------------------------|
| CHECKED Z | APPROYED | DRAWING NO. | REV. E |
| DATE | <u> P</u> | TITLE | SHEET 2 OF 4 SCALE |
| 99.09.20 | | FITTING | 1:1 |





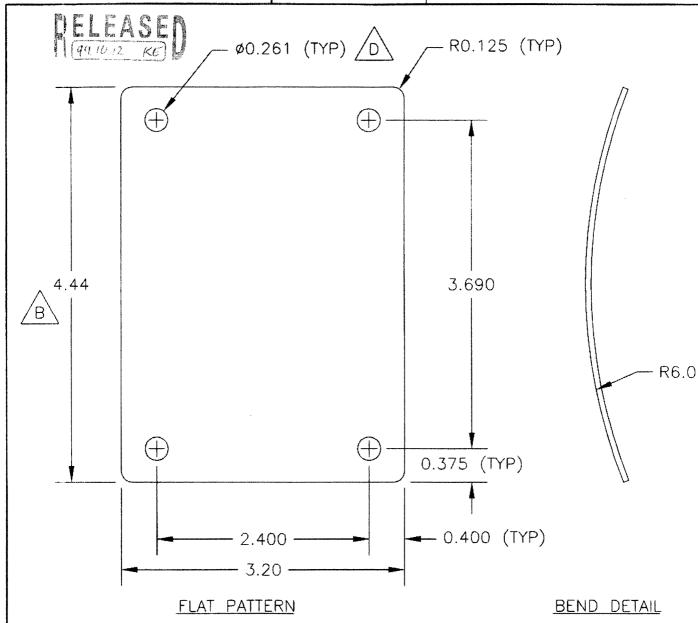
D2249-1 LUG

MATERIAL: AISI 304/316 SS 0.063 THICK ALL DIMENSIONS ARE IN INCHES TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED





| DESIGN | DRAWN BY | | ROSPACE LTD , ontario, canada |
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| CHECKED | APPROYED | DRAWING NO. | REV. E |
| ME | ₩ | D2249 | SHEET 3 OF 4 |
| DATE | | TITLE | SCALE |
| 99.09.20 | | FITTING | 1;1 |



D2249-3 BASE PLATE

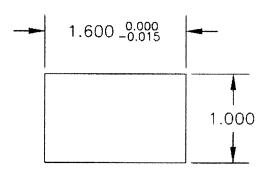
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| DATE | | TITLE | SCALE |
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D2249-5 GUSSET

MATERIAL: AISI 304/316 SS 0.063 THICK ALL DIMENSIONS ARE IN INCHES TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

| DART AEROSPACE LTD | Work Order: 34115 |
|-------------------------------|---------------------|
| Description: / vc. | Part Number: D22491 |
| | |
| Inspection Dwg: D22491 Rev: E | Page 1 of 1 |

| Inspection Dwg | J: D27491 Rev: | E | | | | Page 1 of 1 |
|----------------|----------------|-------------|-------------|----------------|---------------|-----------------|
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| | | ARTICLE IN | | - 1 | | |
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| Drawing | Tolerance | Actual | Accept | Reject | Method of | Comments |
| Dimension | | Dimension | | | Inspection | |
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| 00.261 | 110.000 | \$0.262 | | | Vern | |
| 3.572 | +1.0.010 | 3.573 | / | | Vern | |
| 0.063 | +1.0.016 | 0.057 | | | Jern | |
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| Α | | New Issue | | KJ/JLM | 7.PP7.043.04 |